

Work Order ID 64115

Wednesday, November 24, 2010 2:32:50 PM



Page 1

Item ID: D3531-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 11/25/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: VMF

Date: 10-11-24 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N):

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3531	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

10-11-25

FLOW CNC Waterjet

6061 .040

I-Cut as per Dwg D3531 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary



110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-11-25

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

10-11-25

QC

Quality Control

Memo

0.00

+6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

Bend as per Dwg D3531

0.00

SB 10/12/07

(6)

140



QC5- Inspect part completeness to step on W/O

0.00

8 10/12/07

QC

Quality Control

Memo

0.00

(6)

150



Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10/02/08

HandFinish

Hand Finishing

Memo

0.00

6 8

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

SB 10/12/08

6



QC

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00

Sp 10/12/08

⑥



Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/12/09 (J)

MT
10-12-08

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 64115



Parent Item: D3531-1



Parent Item Name: Bracket

Start Date: 11/25/2010

Required Date: 12/9/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	56.9300	0.3783	1.194632			

6061-T6 .040 Sheet

Location	Loc Qty	Loc Code
MAT21	56.93	
111224	2	
113004	54.93	113004

180-11-25

6

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64115
Description: Bracket	Part Number:	D3531-1
Inspection Dwg: D3531	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	PS	Audited by:	PS	Prototype Approval:	N/A
Date:	10-11-05	Date:	10/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

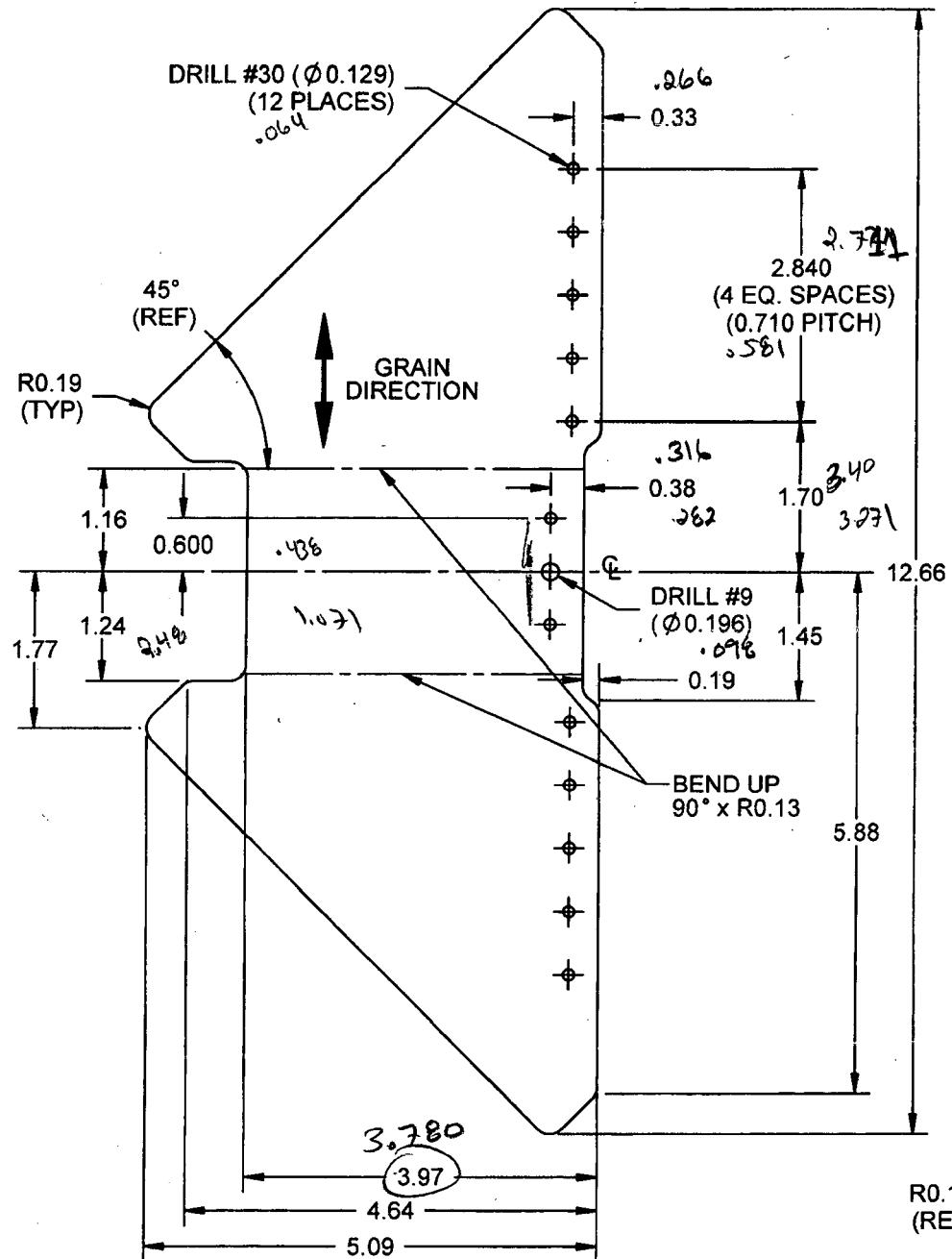
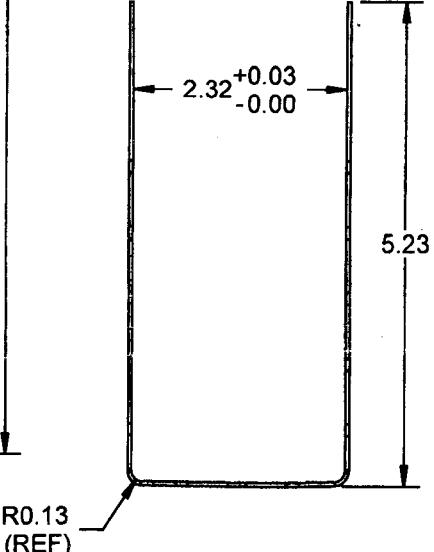
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED MM	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3531-1F FLAT PATTERN****D3531-1 BRACKET****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \mathbb{Q}

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